Page 1

Work Order ID 56404

February 23, 2010 7:00:18 AM

Item ID:

D4046-5

Revision ID:

Item Name:

Mesh Aft End

Start Date:

2/23/10

Start Qty: 1.00

Required Date: 2/23/10

Req'd Qty: 1.00



Accept



Setup Start

Stop



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Set Up/

Run Hours

Date:

Date:

Run Start

Stop



Sequence ID/ **Work Center ID** Draw Nbr

Operation Description

Revision Nbr

D4046

100

Α

Waterjet

FLOW CNC Waterjet

Memo

Dwg Rev: Prog Rev:

Draw

Draw Number Rev.

Plan Code

Accept Qty

Reject Qty

Reject Number

Insp. Stamp

FLOW WATER JET

1-Cut as per Dwg D4046

2-Deburr if necessary

0.00

0.00

B 10-2-23



110

120

QC

QC2- Inspect parts off machine FAI/FAIB

0.00

0.00

R 10-2-23

Quality Control

QC8- Inspect parts - second check

Memo

Quality Control

Memo

Dart Aerospace Ltd	d
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	WORK ORDER CHANGES							
STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
			,					
				!				
	STEP		-	-		STEP PROCEDURE CHANGE By Date Qty Chief Eng /		

Part No: _	PAR #:	Fault Category:	NCR: Yes No DQA:	Date:
	Resolution:	Disposition:	OA: N/C Closed:	Date:

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
		Description of NC		Corrective Action Section B		Verification	_	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspecto

Work Order ID 56404

February 23, 2010 7:00:19 AM

Item ID:

D4046-5

Revision ID:

Item Name:

Mesh Aft End

Start Date:

Required Date: 2/23/10

2/23/10

Start Qty: 1.00 Req'd Qty: 1.00

Operation

Description

Reference:

Approvals:

Sequence ID/

Work Center ID

QC:

Process Plan:

Date:

Date:

Tooling:

Accept

SPC (Y/N):

Set Up/ **Run Hours**

0.00

0.00

Rev.

Draw

Date:

Date:

Plan Code

Accept Qty

Reject Qty

Number Stamp

10.02,23

140

130

Packaging

Packaging

Quality Control

QC21- Final Inspection - Work Order Release

Identify as per dwg & Stock Location:

Memo

Memo

0.00

0.00

10/02/24 A) MF 10-2-23



Cust Item ID:

Customer:

Draw

Number

Setup Start



Stop

Run



Stop



Reject

Insp.

Dart Aerospace Ltd	Dart	Aero	space	Ltd
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W/O:	ļ		WO	RK ORDER CHANG	iES				
DATE	STEP	PRO	OCEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
	:								
Part No	<u> </u>	PAR #:	Fault Categ	ory:	_ NCR: Yes	No DQ	A:	 Date:	
		esolution:							
NCR:			WORK ORDE	R NON-CONFORM	ANCE (NC	R)			
DATE	STEP	Description of NC			ion B	Verific	cation	Approval	Approval
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	& Sect	ion C	Chief Eng	QC Inspector
							<u> </u>		
						, , ,			
						į			

Picklist Print

February 23, 2010 7:00:18 AM

Work Order ID: 56404

Parent Item:

D4046-5

Parent Item Name:

Mesh Aft End

Comments:

IPP RevA: new issue DD 10/01/06 verified by:EC

dwg revA DD 10.02.18 verified by:EC

Start Date: 2/23/10

Required Date: 2/23/10

Required Qty: 1.00

Component Item ID/ Item Name M304EX0.75-16F

Replacement Mfg/ Item ID Purch

Purchased

Primary Item Location No

Last Location

IPP Rev:B as per

Route Seq ID 100

Unit of Measure Hand sf

Qty on

Remaining Qty To Pick Issued 981.9518 3.7278

Start Qty: 1.00

Qty 7.556 Date Issued

Status

Page 1

B 10-2-23

Expanded Metal Flat SS	

Warehouse	Loc Oty	Loc Code		
Location				
Main Warehouse				
MAT	981.9518065			6
111956	0.000017			(3)
112147	9.4736E-06			$\overline{}$
112949	32.58138			
113205	0.0093			
113497	0.1449			
113555	682.7989			
113904	266.4173		113904	

Dart	Aero	space	Ltd
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W/O:

W/O:	WO: WORK ORDER CHA			WORK ORDER CHANGES					
DATE	STEP	PRO	CEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
Part No	:	PAR #:	Fault Category:	NCR: Yes	No DQ	 A:	Date:		

Resolution: _____ Disposition: _____ QA: N/C Closed: ____ Date: ____

NCR: WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC		Corrective Action Section B		Verification	A	A
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector
						!		
							Ī	

DART AEROSPACE LTD	Work Order:	£6404
DART ALROSI AGE LID		
Description: MESH AT FND	Part Number:	D4046-4
Inspection Dwg: D4,46-5 Rev:		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Comments	Method of Inspection	Reject	Accept	Actual Dimension	Tolerance	Drawing Dimension
			>	24.00	4 .30	74.00
		*	*	21.24	1/2 .030	21.75
			<u> </u>	,50	1 .030	,50
		ļ	XX	2,00	7030	7.00
		ļ	*	16.8	1/ .00	15.8
		,	X	17.18	UEO. 4	17.18
		<u> </u>	N	14.43	1/2 ,030	14.43
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			 		1	

Measured by: 12	Audited by:	Prototype Approval:	N/A
Date: 10-9-33	Date: 10/02/23	Date:	N/A

ſ	-	D-4-	Change	Revised by	Approved
Ì	Rev	Date		KJ/JLM	
1	Α		New Issue	(01 0 E1	

8 6 24.00 2.00 ---24.00 8.21 0.50 4.50 0.50 TYP 11.15 11.06 14.80 14.43 21.25 21.25 4.00 9.65 REF R3.50 3 PL R3.50 **D4046-3 MESH FWD END** D4046-5 MESH AFT END NOTES:
1) MATERIAL: AISI 304/316 EXPANDED STAINLESS STEEL MESH 3/4-16F REF DART SPEC. M304EX0.75-16F
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: D4046-3: 1.76 lbs
D4046-5: 1.79 lbs DESIGN DART AEROSPACE LTD DRAWN RF HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. A D4046 MFG. APPR. SHEET 3 OF 4 APPROVED TITLE SCALE BASKET/LID MESH DE APPR. DATE 10.01.29 COPYRIGHT © 2010 BY DART AEROSPACE LTD
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Dart Aerospace Ltd

W/O:			WORK ORDER	CHANGES				
DATE	STEP		PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR	#: Fault Category:	NCR: Ye	s No DQ	A:	Date: _	
	Re	esolution:	Disposition:	QA: N/C	Closed:		Date: _	

NCR:			WORK ORDE	ER NON-CONFORMANC	E (NCR)			
DATE S		Description of NC	Corrective Action Section B			Verification	Annroval	Annroyal
	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector